

T AEROSPACE LTD

Work Order:

20081

Description: Bearpaw Kit (19" x 24")

Part Number:

K10008

Dwg: D2432 Rev. F3

Qty:

20 Kits

Ref: K10008 Rev. E

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HJ	03.12.16	20
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	HJ	03.12.19	10
			HJ	04.01.15	10
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 20.00" x 24.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: M14320	R.G	04.01.05	20
4	MV	Inspect material for defects or damage prior to machining	EP	04.01.24	16
5	MV	Machine as per Folio D2432 and Dwg D2432	EP	04.01.24	16
6	QC2	Inspect parts as they come off the CNC machine	EP	04.01.24	16
7	MV	Deburr	EP	04.01.25	16
8	QC8 & 5	Second inspection	EP	04.02.02	16
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B19540 12 D2274 Radius Block B19599 B19518 2 D2432F 24" Bearpaw B20081 6 D2438 Clamp B20089 B19615 12 D2529 Washer B20090 6 D2732-050 Rubber Cushion B18806 12 AN4-15A Bolt m13437 12 AN4-17A Bolt m12692 24 AN960JD416 Washer m13719 12 MS21042L4 Nut (or -4) m13276 1 Paperwork package from Step 2	EP	04.01.26	16
10	QC4	Inspect Kit for 100% Completeness on the W/O	EP	04.01.26	16
11	PK	Identify and pack for shipping as per PPP K10008	EP	04.01.27	16
12	AC	Cost / part 204.52	SGC	04.02.04	4
13	DC	Close W/O 239.79 Inspect Level 21	HJ	04.02.05	4

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	

RELEASED

1000-1000-1000

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
		REFERENCE ONLY					

NCR 20081B K10008		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04.02.02	5	1 bearing scrap, hole misaligned - operator error.	<i>[Signature]</i>	Scrap destroyed put remaining in stores D2432F	<i>[Signature]</i> 04.02.02	<i>[Signature]</i> 04.02.02	<i>[Signature]</i>	<i>[Signature]</i> 04.02.02
		Sylvain wanted to stir shit so he said parts were no good						

PAR#: _____ Fault _____ Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____



Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20081A K10008		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04.02.02	5	1 Deepaw scrap, hole misaligned - operator error.	<i>[Signature]</i>	Scrap destroy	<i>[Signature]</i> 04.02.02	<i>[Signature]</i> 04.02.02	<i>[Signature]</i>	<i>[Signature]</i> 04.02.02
		Sylvain wanted to chir shirt as he said pants were no good						
								Scrap Scrap.


 PAR#: N/A Fault Category: manuf. cnc DQA: *[Signature]* Date: 04.02.03



 NOTE: Date & initial all entries
 H:\Admin-QA\ISO\forms\w\oncB.doc

 QA: N/C Closed: *[Signature]* Date: 04.02.03



DART AEROSPACE LTD	Work Order:	200813
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	3 Kits
Ref: K10008 Rev. E		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required		04.02.02	3
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)			
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G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
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Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20081B
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

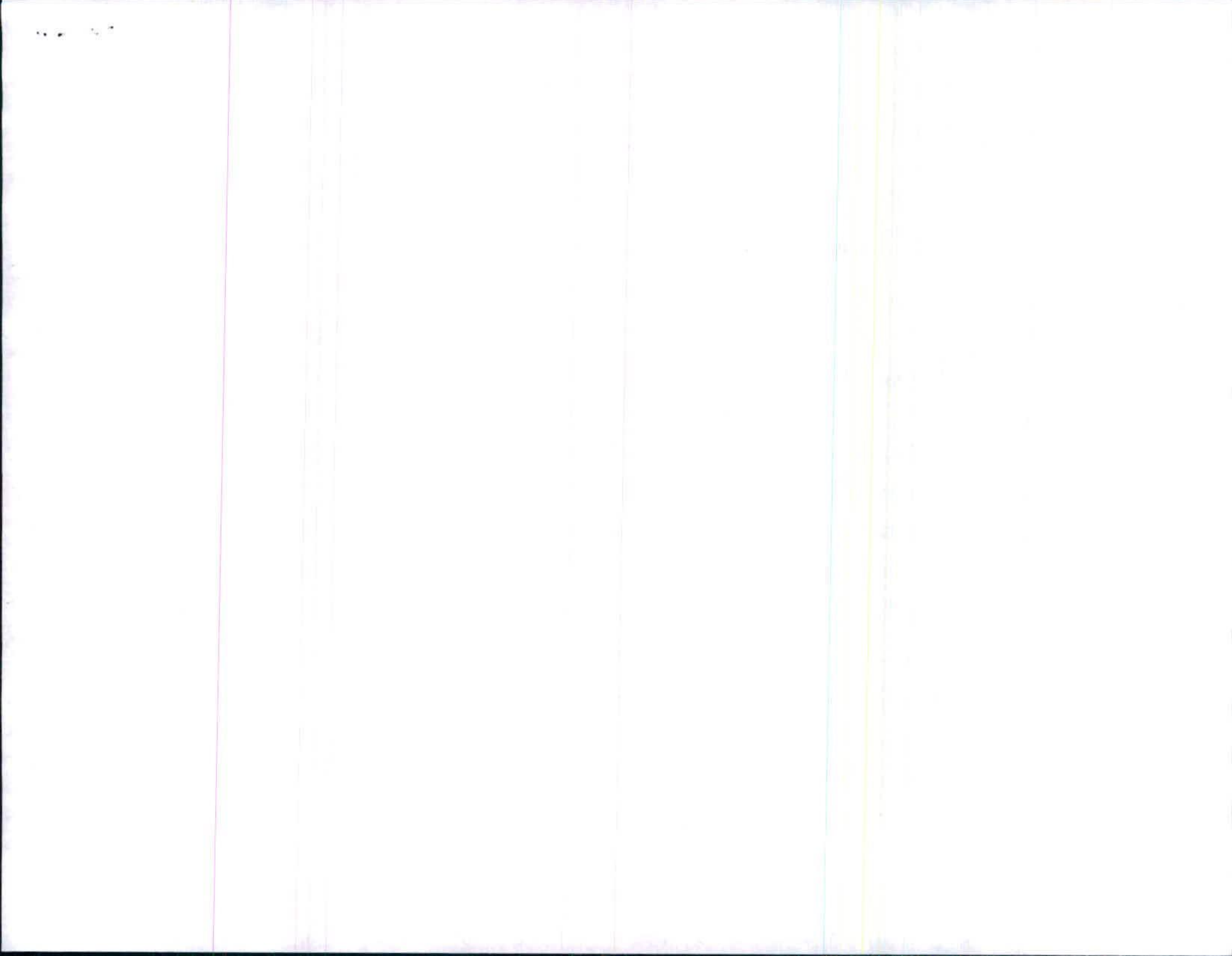
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010					
B	5.500	+/-0.030					
C	0.200	+/-0.030					
D	0.25 x 45°	+/-0.030					
E	R0.250	+/-0.030					
F	0.250	+/-0.010					
G	0.625	+/-0.030					
H	0.375	+/-0.010					
I	0.950	+0.030/0.010					
J	19.000	+/-0.030					
K	3.14	+/-0.030					
L	3.28	+/-0.030					
M	Ø0.260	+0.005/-0.000					
N	Ø0.93	+/-0.030					
O	0.30	+0.030/-0.000					
P	23.750	+/-0.030					
Q	7.375	+/-0.030					
R	4.250	+/-0.010					
S	2.000	+/-0.030					
T	9.000	+/-0.010					
U	9.000	+/-0.010					
V	0.375	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

RELEASED

04.01.15



The following is a list of the names of the persons who have been named in the records of the court in the case of the State of New York vs. John Doe and Jane Doe, et al. The names are listed in alphabetical order of the last name.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 02, 2004
01:43 pm

Work Order No	: 0020081B	Department Code:	
Project Name	: *K10008	Burden Flags	: NNNNNNN
Project For	: WK406	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10008	Invoice Number	:
Description	: Bearpaw kit 19" x 24"	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 3	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 02-02-04		
Est Finish Date	: 02-04-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD		Work Order: 20081 B
Description: BEAR PAW		Part Number: 02432
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063x45°	±0.010	0.063x45°	✓			
B	5.500	±0.010	5.500	✓			
C	0.200	±0.010	0.194	✓			
D	0.25x45°	±0.030	0.25x45°				
E	R 0.250	±0.010	0.250	✓			
F	0.250	±0.010	0.249	✓			
G	0.625	"	0.624	✓			
H	0.375	"	0.385	✓			
I	0.950	"	0.942	✓			
S	19.000	"	19.000	✓		TAPE MEASURE	
IL	3.14	±0.030	3.139	✓			
L	3.20	"	3.230	✓			
M	0.260	±0.010	0.260	✓			
N	0.93	±0.030	0.925	✓			
O	0.30	"	0.327	✓			
P	23.750	±0.010	23.750	✓			
Q	6.750	"	6.753	✓			
R	4.250	"	4.250	✓			
S	2.000	"	1.993	✓			
T							
U							
V	0.375	±0.010	0.365	✓			

Measured by: EP	Audited by: EC	Prototype Approval: N/A
Date: 04/02/01	Date: 04.02.01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

